

Order ID 68570

ay, April 18, 2011 11:32:42 AM



Page 1

Item ID: D3204-041

Accept



Setup Start



Revision ID:

Item Name: Release Pedal Assembly

Stop



Start Date: 4/18/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-04-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. □2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. □3- Use JB weld compound to plug the hole after assembly. □4- Grind JB weld flush after it is cured. □Ident

*M 114703.**11-8-2**16*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*11.08.03**6*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Subtotal**16*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 68570




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Page 2

Item ID: D3204-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Release Pedal Assembly
Start Date: 4/18/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 4/21/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							<u>X6</u> <u>φ</u> <u>Mu108/03</u>
140  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <u>11117338</u> Memo ***Cover holes for bushing*** START TIME: <u>11:30A</u> OVEN TEMPERATURE: <u>12:00</u> FINISH TIME: <u>3:20P</u>	0.00 0.00							<u>X6</u> <u>φ</u> <u>Mu108/03</u>
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<u>6X</u> <u>φ</u> <u>Mu108/03</u>

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Item ID: D3204-041

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Setup Start

Revision ID:

Stop

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Start Date: 4/18/2011 Start Qty: 4.00

Required Date: 4/21/2011 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Install D3204-7 bushing as shown in Dwg D3204

4/11/08/09 (6)

170

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

8/4/08/09

(76)

180

0.00



Packaging

Packaging

Identify as per dwg & Stock Location:

G-A

Memo

0.00

4/11/08/12 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Revision ID:
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Start Date: 4/18/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 4/21/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

CK 4/08/12

2/11-08-11
(6)

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NOTE: Date & initial all entries

Picklist Print

Monday, April 18, 2011 11:32:49 AM

Page 1

Work Order ID: 68570

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 4/18/2011


Required Date: 4/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: ☐ C ☐ 05.08.11 ☐ Added Step 25 ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3204-1  Tube		Manufactured	No			100	Each	2.0000	1	4			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

68571 X4

Location

Loc Qty


Loc Code

WA019

2

60883

2

D3204-11  Plate		Manufactured	No			100	Each	36.0000	1	4			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location

Loc Qty

Loc Code

ST45

14

57522

14

WA019

22

55463

22

D3204-3  Arm		Manufactured	No			100	Each	7.0000	1	4			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

70317 X6

Location


Loc Qty

Loc Code

WA019

7

1

D3204-5  Arm		Manufactured	No			100	Each	6.0000	1	4			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

70320 X6

Location

Loc Qty

Loc Code

WA

6

65140

6

W/O:		WORK ORDER CHANGES					
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Monday, April 18, 2011 11:32:49 AM

Page 2

Work Order ID: 68570

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 4/18/2011

Required Date: 4/21/2011

Start Qty: 4.00

Required Qty: 4.00

D3204-7 Manufactured No

100

Each

13.0000

2

8



Bushing

Location

Loc Qty

Loc Code

ST041

13

60871

13

D3204-9 Manufactured No

100

Each

4.0000

1

4



Pedal

60884x3

68573x3

Location

Loc Qty

Loc Code

WA

4

65141

4

D3204-13 Manufactured No

160

Each

12.0000

2

8



Gusset

Location

Loc Qty

Loc Code

WA019

12

58211

12

EP 11/08/09
B70323 (1W)

EL 11-8-2

EL 11-8-2

12

Monday, April 18, 2011 11:32:50 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

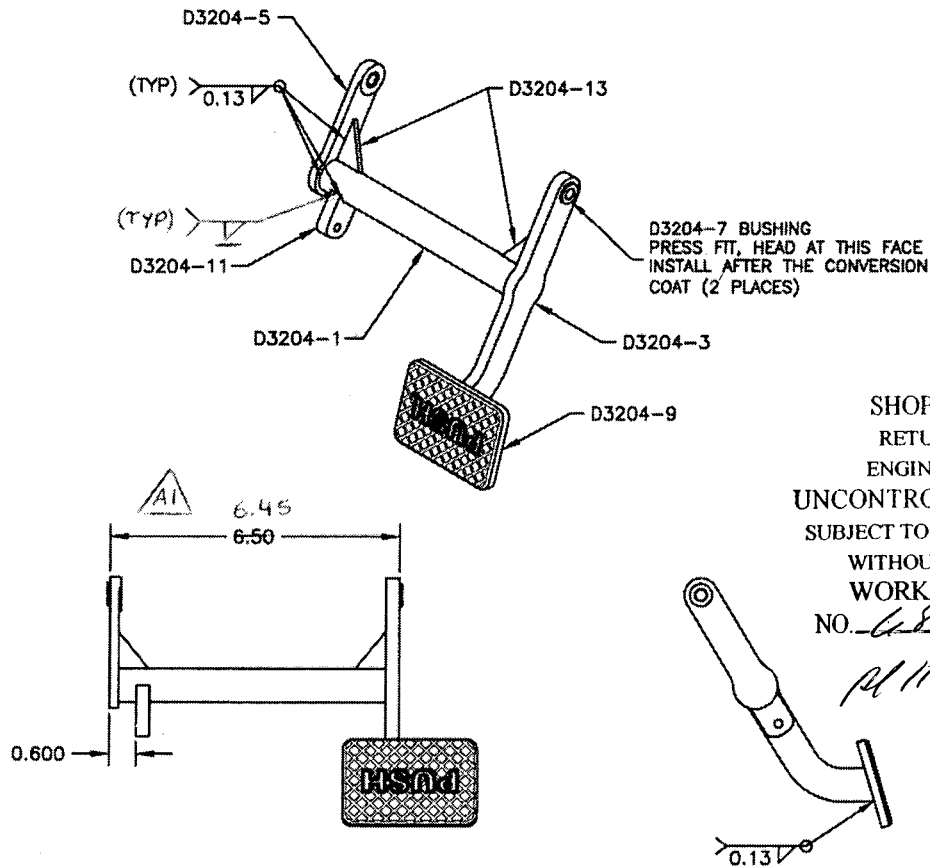
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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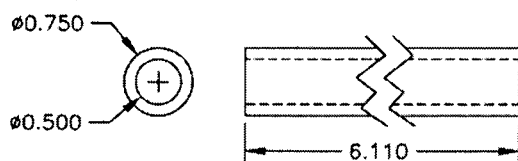
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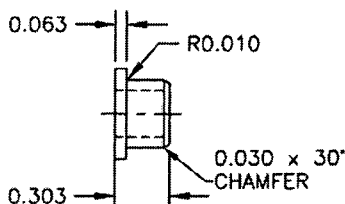


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

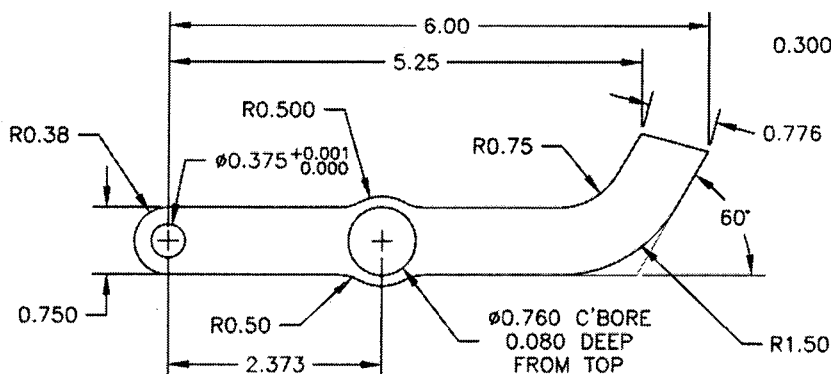
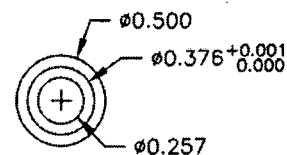
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04.04.05 [Signature]



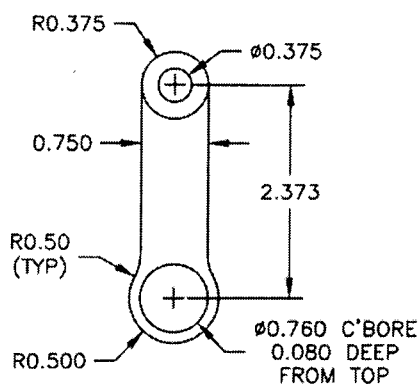
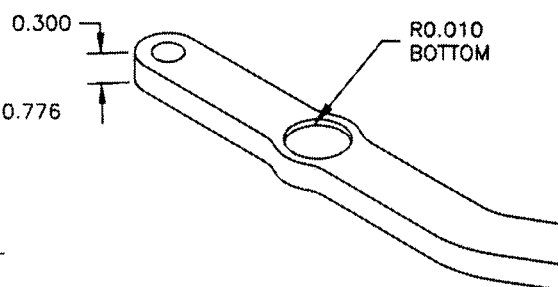
2 D3204-1 TUBE
SCALE 1:2



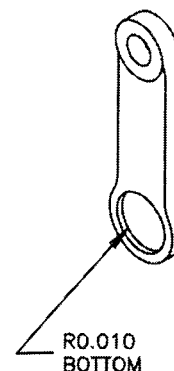
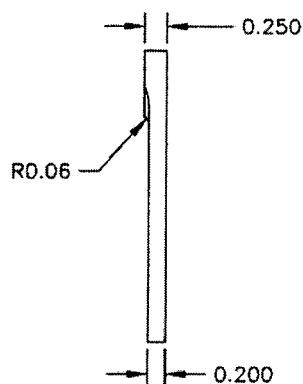
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



w/068570

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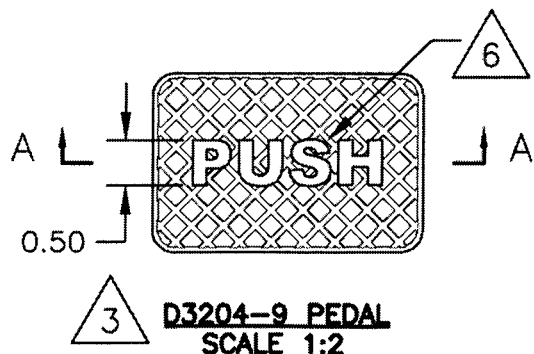
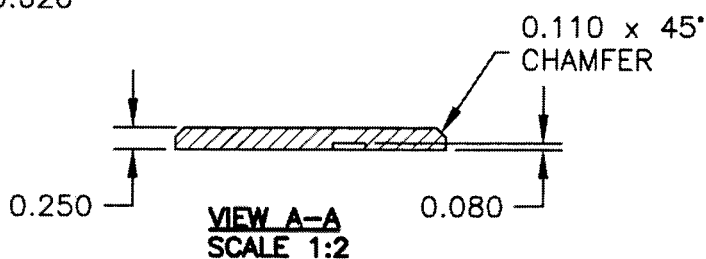
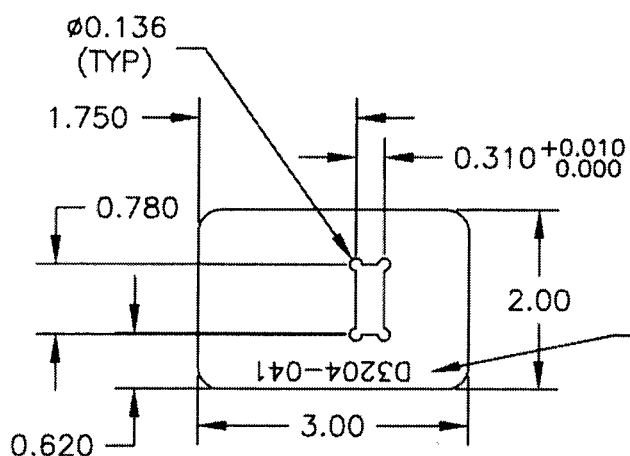
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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

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04.04.30



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